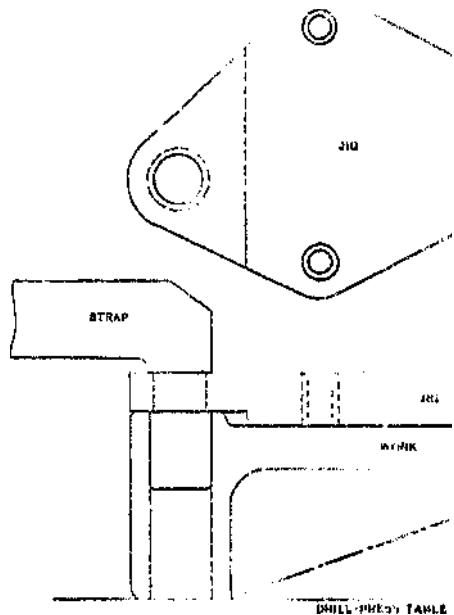


to insure getting the proper amount of metal around the hole *D*. At the bottom it is located against the sliding' point /*i*, the latter being adjustable, because the location of the work, is determined by the other locating points and surfaces. The work is held against the locating points by the long set-screw shown to the left. This clamping arrangement, however, is not to be recommended, because this screw must be screwed hack a considerable distance in order to permit insertion and removal of the work.



a
 <<*tH' * \$

**Fig. 17. Simple Plate Jig
for Drilling** Bracfett shown in
Fig. 15,

**after Hole B has
been Bored in the
Lathe**

An eye-bolt used in the manner described in a preceding chapter would have given better service. The three straps 6* hold the work against the bottom surface, and the two straps // hold it against the finished surface at *B*. There is not a long finished hole through the casting, as would be assumed from its appearance, but simply a short bearing at each end, the remaining part of the hole being cored out. For this reason, the hole is drilled and reamed instead of being bored out, as the latter operation